

# Work Order ID 86161

\*86161\*

Page 1

Jun-21-12 10:05:41 AM

Item ID: D119-675-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step RH

Start Date: 21/06/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
N/A	Rev N/A								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 119-675-012 CHG004								
110		0.00							
<b>*110*</b>	Pick Kit								
Packaging	Memo	0.00							
Packaging									
120		0.00							
<b>*120*</b>	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

DAS 16 12/6/17 JB

MLJ 12-6-29

4

30

4

12/06/29 JB

DAS 16 12/6/17

4 RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86161****\*86161\***

Page 2

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Item ID: D119-675-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 21/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-012								
	Location: <u>70</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

6/21/12 (4)12/7/18 J

ME

12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

June-21-12 10:05:46 AM

Page 1

Work Order ID: 86161

\*86161\*

Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01  
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3043-042		Manufactured	No			110	Each	0.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3043-042\*

Step Weldment RH, A119

D2182B032		Manufactured	No			110	Each	10.0000	4	16			
-----------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

\*D2182B032\*

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

10

73932

10

D2274-2		Manufactured	No			110	Each	759.0000	8	32			
---------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

\*D2274-2\*

Radius Block

Location

Loc Qty

Loc Code

ST007

759

78233

2

81958

96

83258

210

84199

251

85455

200

73932

32

81958

12/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-21-12 10:05:46 AM

Page 2

Work Order ID: 86161

\*86161\*

Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2617-3 Manufactured No

110 Each

28.0000

\*D2617-3\*

Bushing

4 16 ✓  
\*\* 4x 86394 JB

Location

Loc Qty

Loc Code

FG 10

27991 10

ST012 18

76948 6

84008 12

D2617-5 Manufactured No

110 Each

36.0000

\*D2617-5\*

Spacer

12x84008  
32 ✓  
\*\* 6x 86395 JB

Location

Loc Qty

Loc Code

FG 10

31756 10

ST012 26

81814 10

85423 16

D2732-032 Manufactured No

110 Each

0.0000

\*D2732-032\*

RUBBER CUSHION

10x81814  
16x85423  
12.01.17  
20987 JB

D3041-1 Manufactured No

110 Each

0.0000

\*D3041-1\*

Clamp

4 16 ✓  
\*\* 84000 JB

D3041-3 Manufactured No

110 Each

8.0000

\*D3041-3\*

Clamp

2 8 ✓  
\*\* 84001 JB 12/06/27

Location

Loc Qty

Loc Code

ST462 8

51114 8

June-21-12 10:05:46 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-21-12 10:05:46 AM

Page 3

Work Order ID: 86161

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

\*86161\*

\*D119-675-012\*

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3042-1  
\*D3042-1\*  
Clamp

Manufactured No

110 Each

27.0000

4

16

\*\*

JB

SD

## Location

## Loc Qty

## Loc Code

ST457

27

83999

27

110 Each

264.0000

4

16

\*\*

83999 JB

SD

AN4-11A  
\*AN4-11A\*  
Bolt

Purchased No

## Location

## Loc Qty

## Loc Code

ST356

264

118706

14

120731

100

121243

50

121708

100

110 Each

534.0000

8

32

\*\*

121708

JB 12/06/27

SD

AN4-12A  
\*AN4-12A\*  
Bolt

Purchased No

## Location

## Loc Qty

## Loc Code

ST357

534

115422

4

119775

28

120423

477

121524

25

47 115422  
28 119775

June-21-12 10:05:47 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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June-21-12 10:05:47 AM

Page 4

Work Order ID: 86161

\*86161\*

Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

110

Each

762.0000

16

✓

\*AN4-15A\*

Bolt

\*\*

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

562

118706

3

120422

1

121541

158

122141

400

121541

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

48

✓

\*AN960JD416\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

2,691.000

48

✓

\*MS21042L4\*

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

2691

119075

116

121011

193

121444

2082

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## 4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™</i> , LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™</i> , RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

## 5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042-4	NUT (OR MS21042-4)

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Revision: B

Date: 07.10.23